

Date: Wednesday, 22/10/2008 11:56:18 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAP
Job Number : 42806	
Estimate Number : 10519	
P.O. Number :	Part Number : D2855
This Issue : 22/10/2008 S.O. No. :	Drawing Number : D2855 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision :
Previous Run : 35920	Material :
Written By :	Due Date : 06/01/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 08.10.22</u>	
Comment : Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 7431C208110/23

Cast per Dwg D2855

Material Release Note Required

(12)

2.0	D2855P	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

P 8/11/20 (12)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECKS 08/11/20 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr

C 08/12/23 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CAP

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/05 (12)

7.0

POWDER COATING

POWDER COATING



M 102316



(12X)

Comment: POWDER COATING

~~12~~

Powder Coat **SANDTEX GREEN**

(Ref: 4.3.5.1) as per QSI 005 4.3

*

M-1

08/12/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT

08-12-05

(12)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

M100621

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

gH

9.1

ALS41032225

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Insert

gH

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

HL

08-12-05

(12)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-12-05

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CAP

Job Number: 42806

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Finishing*

W : 08-12-08

(12)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/09 *[Signature]*

Job Completion



mf 08-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

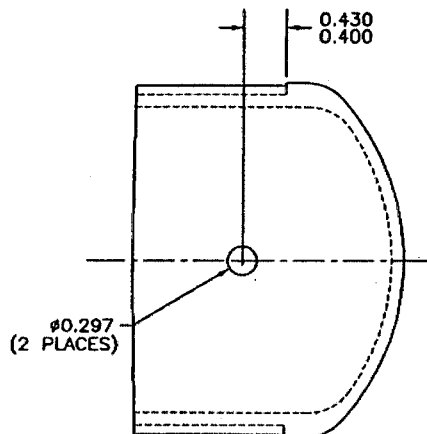
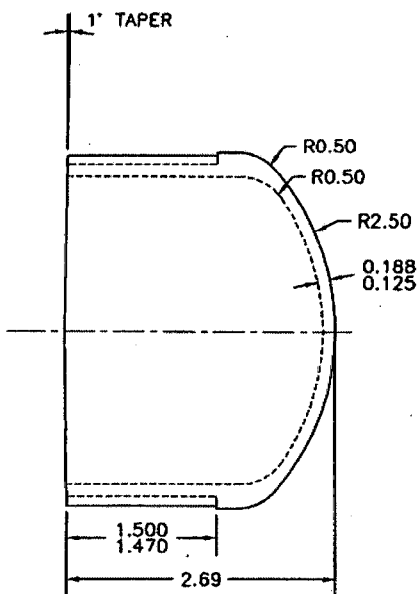
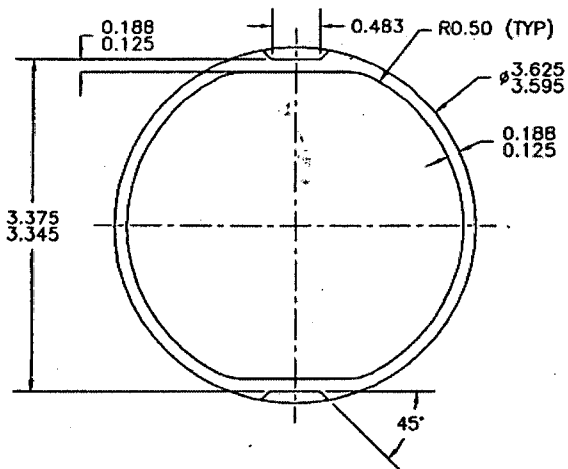
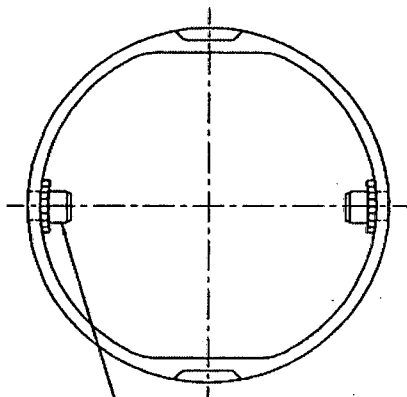
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>AE</i>	DRAWING NO. D2855	REV. A
DATE 98.12.12	TITLE CAP	SHEET 1 OF 1	
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)	
		SCALE NTS	

RELEASED
98.12.14
DS**D2855 CASTING DETAIL****D2855 FINISHING DETAIL**

INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 42800

Aluminum Foundry Ltd

714-716 Calais
Dorval, Québec H9P 2P3
Tel: (514) 631-1331
Fax: (514) 631-8448

Packing Slip

Packing Slip No.:

32829

Date:

Nov 21, 2008

Page:

1

Sold to:		Ship to:	
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7		DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	
Order No.: 7431		Sold By:	
Shipped By: FEDEX		Ship Date: Nov 21, 2008	
Tracking No.: 8491 8012 0924			

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	30
Comment:			

70 CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714 716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing
Date: **21/11/2008** Slip No. **32829**

Hawksbury, ON, K6 1K7

Votre No. Commande **00007431**
Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
30	D 2855 CAP	Z098046	A356.2	ingot#851118

Analyse
Analysis (as in Ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.42%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donnée
Yield : Résistance à la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation : %

Pour et au nom de
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :
Par/Per :

Coc-100

